

Date: Monday, 7/30/2007 1:54:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD	
Job Number	33804				
Estimate Number	12784				
P.O. Number	N/A		Part Number	D35649	
This Issue	7/30/2007	S.O. No.	N/A	Drawing Number	D3564 REV C
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision	C
Previous Run	33457		Material	N/A	
Written By			Due Date	8/28/2007	
Checked & Approved By			Qty:	12	
Comment	Est Rev:A New Issue 07-03-08 ec		Um:	Each	
	Est Rev:B As per Rev C 07-07-09 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.9177 sf(s)/Unit Total : 11.0124 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M105136</u> <u>IB 07-07-31</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)**** Dwg Rev: <u>C</u> <u>IB 07-07-31</u> Prog Rev: <u>C</u>		
2-Deburr if necessary <u>09/03/07 fm (12)</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>IB 07-07-31</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>07/08/07 (412)</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT		
<u>FF 07-08-08</u> <u>12</u>		
Form Joggle as per Dwg D3564 on brake using Jig DT		
<u>FF 07-08-08</u> <u>12</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: D Date: 07/08/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:54:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33804

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Ex 07/08/08 (12) counter

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M105138

Weld hardcoat as per Dwg D3437

88 07/08/17 X12

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11 07/08/20 (12)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11 07/08/20 (12)

10.0 POWDER COATING

POWDER COATING



m104846

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Ex 07/08/21 (12)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-1 07/08/21

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

BR/m-h 0708-21

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11 07/08/22

Job Completion



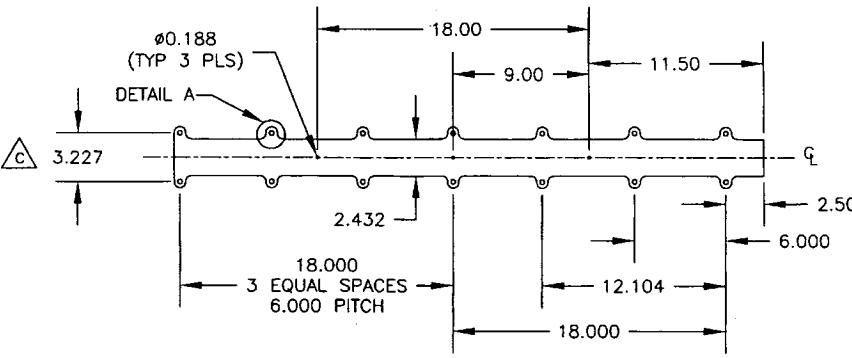
u 07/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

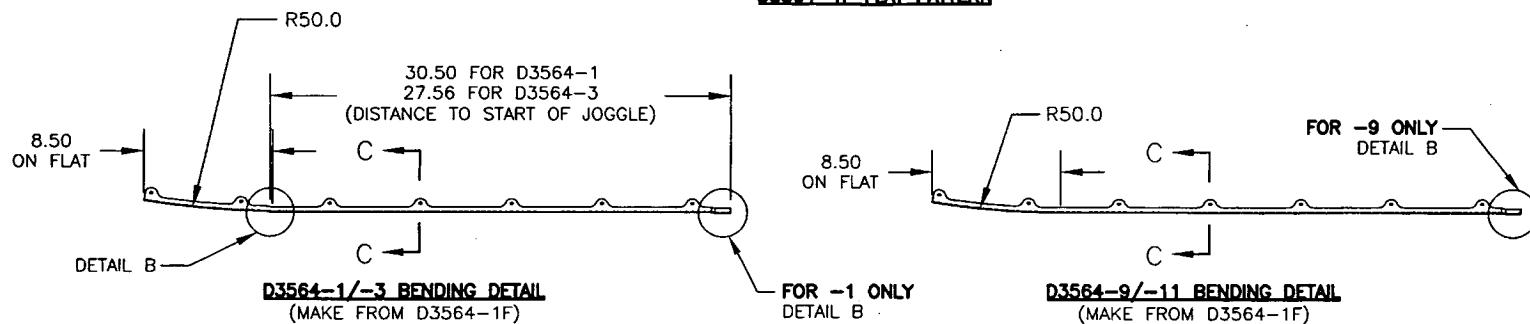
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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1/-3/-9/-11 WELDING DETAIL**

NO. 33804  
WORK ORDER  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
SHOP COPY  
RETURN TO

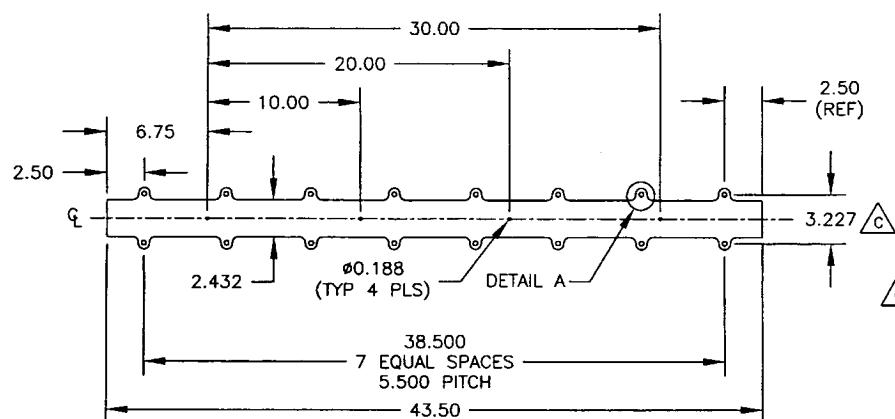
**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

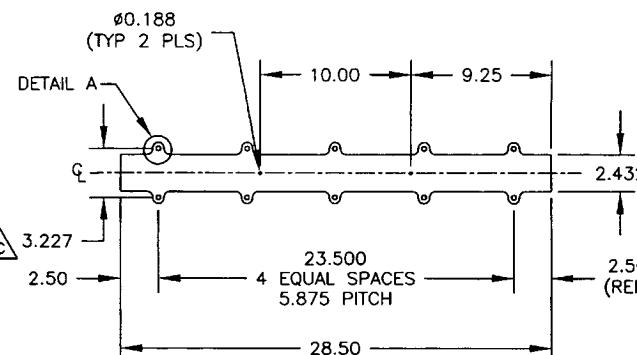
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DART AEROSPACE LTD.

C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
PJ	PJ	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
H	H	D3564
DATE	TITLE	REV. C
07.04.17	WEARSHOE	SHEET 1 OF 2
		1:8

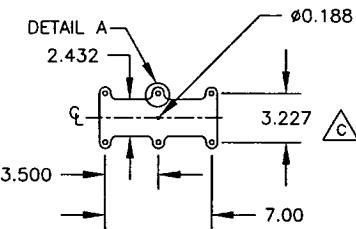
**RELEASED**  
07.06.28



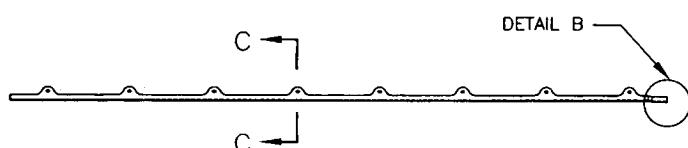
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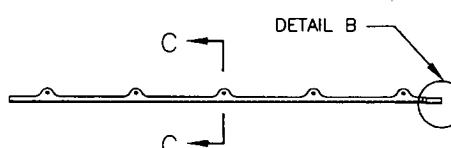
**D3564-7F FLAT PATTERN**



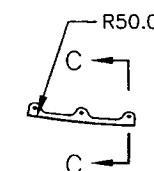
**D3564-13F FLAT PATTERN**



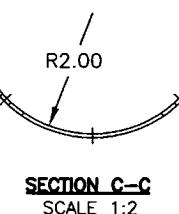
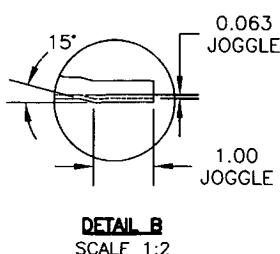
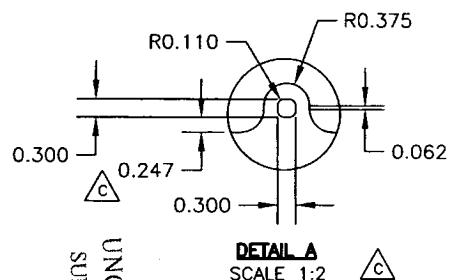
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**RELEASED**  
07.06.28/17

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
1	PJ		
1	1	1	DRAWING NO. D3564
DATE 07.04.17	TITLE WEARSHOE	REV. C SHEET 2 OF 2 SCALE 1:8	

NO. 33804  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

DART AEROSPACE LTD	Work Order:	33804
Description: WEAR PAD	Part Number:	J3564-9
Inspection Dwg: D3564 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	EN	Prototype Approval:	
Date:	07-07-31	Date:	07/08/01	Date:	W/B

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	